

5/15

Skit

DART AEROSPACE LTD		Work Order:	22493B
Description: Bearpaw Kit (19" x 24")		Part Number:	K10008
Dwg: D2432 Rev. F3		Qty:	11 <del>25</del> Kits
Ref: K10008 Rev. E; DSK086-5 Rev. A		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	HF	05.02.21	15
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)	Wk 13 HF	05.03.17	14
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10)	Batch: M15926	ML	05/03/17 14
4	MV	Inspect material for defects or damage prior to machining	ML	05/03/17	14
5	MV	Machine as per Folio D2432 and Dwg D2432 Identify as D2432F	ML	05/03/17	14
6	QC2	Inspect parts as they come off the CNC machine	ML	05/03/17	14
7	MV	Deburr	ML	05/03/17	14
8	QC8 & 5	Second inspection	EC	05/03/17	14
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) Qty Part Number Description Batch 6 D2182B050 Rubber Cushion B20434/B19540/B21185 12 D2274 Radius Block B20927/B21585/B21846 2 D2432F 24" Bearpaw B22493 6 D2438 Clamp B21189 12 D2529 Washer B21587A 6 D2732-050 Rubber Cushion B20433 12 AN4-15A Bolt M15321 12 AN4-17A Bolt M14526 24 AN960JD416 Washer M13993 12 MS21042L4 Nut (or -4) M15020 1 Paperwork package from Step 2			
10	QC4	Inspect Kit for 100% Completeness on the W/O	JG	05/03/17	11
11	PK	Identify and pack for shipping as per PPP K10008 Rev. E	CY	05/03/17	11
12	AC	Cost / part 251.50	SYC	05.03.21	11
13	DC	Close W/O 274.25 Inspect Level 21	HF	05.03.17	11

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector		
			Initial Design Mgr	Action Description Design Mgr	Sign & Date					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD	Work Order:	22493
Description: Bearpaw	Part Number:	D2432F
Inspection Dwg: D2432	Rev: F3	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.060	✓	—	Ucm	
B 5.500	+/-0.030	5.500	✓	—	Ucm	
C 0.200	+/-0.030	0.203	✓	—	Ucm	
D 0.25 x 45°	+/-0.030	0.230x45°	✓	—	Ucm	
E R0.250	+/-0.030	R0.250	✓	—	R-G	
F 0.250	+/-0.010	0.254	✓	—	Ucm	
G 0.625	+/-0.030	0.612	✓	—	Ucm	
H 0.375	+/-0.010	0.382	✓	—	Ucm	
I 0.950	+0.030/0.010	0.960	✓	—	Ucm	
J 19.000	+/-0.030	19.000	✓	—	M-Tape	
K 3.14	+/-0.030	3.126	✓	—	Ucm	
L 3.28	+/-0.030	3.270	✓	—	Ucm	
M Ø0.260	+0.005/-0.000	Ø0.260	✓	—	Ucm	
N Ø0.93	+/-0.030	Ø.929	✓	—	Ucm	
O 0.30	+0.030/-0.000	0.305	—	—	Ucm	
P 23.750	+/-0.030	23.750	✓	—	M-Tape	
Q 7.375	+/-0.030	7.375	✓	—	Ucm M-Tape	
R 4.250	+/-0.010	4.250	✓	—	M-Tape	
S 2.000	+/-0.030	2.000	✓	—	Ucm	
T 9.000	+/-0.010	9.000	✓	—	M-Tape	
U 9.000	+/-0.010	9.000	✓	—	M-Tape	
V 0.375	+/-0.010	0.380	✓	—	Ucm	

Measured by: mv  
Date: 05/03/07

Audited by:	SA
Date:	6303.09

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/o K10008/D206-559-015	KJ/RF

H:\FORMS\Quality Assurance\approved QA\FAIB RevA

RELEASED

2015-04-24





## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyFeb 21, 2005  
07:40 am

Work Order No : 0022493  
 Project Name : K10008  
 Project For : WK515  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : \*K10008  
 Description : Bearpaw kit 19" x 24"  
 Manufactured : Yes  
 Amount Req'd : 20  
 Amount Done : 0  
 Start Date : 02-18-05  
 Est Finish Date : 03-30-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :  
 Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Margin : 0.000%  
 Actual Margin : 0.000%  
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00	0.00	0.00
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00	0.00	0.00
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00	0.00	0.00
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00	0.00	0.00
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00	0.00	0.00
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00	0.00	0.00
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00	0.00	0.00
Total Cost	0.00	0.00	0.00	0.00	0.00
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00